

Work Order ID 45455

June 29, 2009 1:00:34 PM



Page 1

Item ID: D130-780-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD RH

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photo copy bluefile and type labels per PPP D130-780-042 CHG 001

for CL 09/07/14

509/02/14

110

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

⇒ 509/02/14 to

120

0.00



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D130-780-042 Location: _____ PPP Rev: _____

0.00



Work Order ID 45455

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Page 2

Item ID: D130-780-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD RH

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/14

9-07-14

Picklist Print

June 29, 2009 1:00:33 PM

Page 1

Work Order ID: 45455

Parent Item: D130-780-042RevA










Parent Item Name: SPACEPOD RH

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009**Start Qty: 1.00**

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
A3235-020-935 		Purchased	No				Each	815.0000	8.0000			
Washer - Countersunk A3235-020-935 		Purchased	No				Each	815.0000	1.0000			
Washer - Countersunk AKS4-1032-130 <i>on 7 ALSY ?</i> 		Purchased	No				Each	1.0000	28.0000	<i>7/1/05/11</i>	<i>9/7/6</i>	
Inserts AKS4-1032-130 		Purchased	No				Each	1.0000	10.0000			
Inserts AN3-10A 		Purchased	No				Each	127.0000	2.0000	<i>17566</i>		
Bolt AN3-3A 		Purchased	No				Each	229.0000	4.0000	<i>111925</i>		
Bolt AN3-6A 		Purchased	No				Each	138.0000	4.0000	<i>109752</i>		
Bolt AN525-10R7 		Purchased	No				Each	268.0000	38.0000	<i>(34) 110844</i>	<i>11/4/77</i>	
Screw AN526-832R24 <i>ANS26C832R24</i> 		Purchased	No				Each	213.0000	4.0000	<i>104603</i> <i>7/1/68/95</i>	<i>9/7/6</i>	

Picklist Print

June 29, 2009 1:00:33 PM

Work Order ID: 45455

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH










Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN526C832R14 		Purchased	No		9/7/6		Each	1,051.000	8.0000	104916	56	✓
Screw												
✓ AN5-5A 		Purchased	No		9/7/6		Each	116.0000	1.0000	110363	54	✓
Bolt												
AN960JD10 		Purchased	No		9/7/6		Each	1,246.000	8.0000	111668	54	✓
Washer												
AN960JD516 		Purchased	No		9/7/6		Each	1,603.000	3.0000	111279	50	✓
Washer												
D130-780-013RevA 		Manufactured	No		9/7/6		Each	5.0000	1.0000	45534	2	✓
SWITCH RELOCATION KIT												
✓ D130-780-044RevA 	RV58	Manufactured	No				Each	0.0000	1.0000			
SPACEPOD RH												
D2237RevD1 		Manufactured	No				Each	30.0000	2.0000	1346162	9/7/6	✓
Striker Plate												
✓ D3015-3RevB 		Manufactured	No		9/7/6		Each	435.0000	1.0000	48328	54	✓
Locknut												
✓ D3188-2MRevE 	RV5	Manufactured	No				Each	0.0000	1.0000	45534		
SPACEPOD BODY RH												

June 29, 2009 1:00:33 PM

Shop Packet Print

Picklist Print

June 29, 2009 1:00:33 PM

Work Order ID: 45455

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH










Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3538-1RevA 		Manufactured	No				Each	40.0000	2.0000	44650	9/7/3	✓
Hinge Bracket												
✓ D3547-1RevA 		Manufactured	No		9/7/6		Each	20.0000	1.0000	35455		SD
Bracket												
✓ D3550-1RevB 		Manufactured	No		9/7/6		Each	31.0000	1.0000	36226		SD
Strut												
✓ D3554-7RevA 		Manufactured	No		9/7/6		Each	81.0000	1.0000	37674		SD
Ball Stud												
✓ D3798-042RevA 		Manufactured	No				Each	2.0000	1.0000			
Spacepod Floor												
✓ D3815-041RevA 		Manufactured	No				Each	17.0000	2.0000			
Web Assembly												
✓ D3837-1RevB 		Manufactured	No				Each	12.0000	1.0000			
Decal												
✓ D3837-4RevB 		Manufactured	No				Each	11.0000	1.0000	346233	9/7/3	✓
Decal												
✓ MS20426AD4-5 	MS20426AD4-5	Purchased	No		9/7/6		Each	7,958.000	4.0000	4067		✓ SD
Rivet												

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Shop Packet Print

Picklist Print

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Work Order ID: 45455

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH








Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS21042L3 		Purchased	No		9/1/6		Each	1,873.000	16.0000	11/27/		SO
Nut ✓ MS21042L5 		Purchased	No		9/1/6		Each	791.0000	1.0000	11/27		SO
* Nut MS21042L8 <i>208</i> 		Purchased	No				Each	41.0000	4.0000	M111889		
✓ Nut MS24694-S67 		Purchased	No				Each	167.0000	7.0000			
✓ Screw MS24694-S69 		Purchased	No				Each	27.0000	1.0000			
✓ Screw NAS1149D0332J 		Purchased	No		9/1/6		Each	271.0000	16.0000	M110625		SO ✓
Washer ✓ NAS1149DN832J 		Purchased	No				Each	107.0000	4.0000			
WASHER												

D2586 B47183

NAS155H3 M110397

MS2703 9-0811 M108335

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Shop Packet Print

Page 4

Date: Wednesday, 25/03/2009 10:53:23 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD RH, EC 130 B4
Job Number	: 45455		
Estimate Number	: 13762		
P.O. Number	:	Part Number	: D130780042
This Issue	: 25/03/2009 S.O. No. :	Drawing Number	: IIN-D130-780
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 03/02/2009 Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 45454	Material	:
Written By	:	Due Date	: 01/03/2009
Checked & Approved By	: <u>JUD 09.03.25</u>	Qty:	1 Um: Each
Comment	: Est Rev:A 09-02-03 new issue DD verified by:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP D130-780-042 CHG 001

2.0

D130780044

Spacepod Door Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door Assembly, RH

batch: 45693

090713

3.0

D130780013

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Relocation

batch: 45534

4.0

D31882M

SPACEPOD BODY RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACEPOD BODY RH

batch: 45101A

5.0

AKS71032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Insert

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45455

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D38374

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: _____

7.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

batch: _____

8.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch: _____

9.0

D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Hinge Bracket

batch: _____

10.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

screw

batch: _____

11.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

12.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45455

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- Assemble as per dwg D3188,
- use door to transfer drill hole location.
- Install inserts

AS 090713

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sat 02/13 *20*

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005.4.4
Batch: *111013*

BY 09-07-13

(1)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-07-13

(20)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D3815041

Web Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Web Assembly

batch: *134529*

CC

19.0

D38371

Decal





Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: *1346231*

1346231 *(1)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
090713	13	Modify BOTTOM inside of Body 902 cloth FG781050550 M11166 .3yd 9330 Hysol M112165 SEE DS EMAIL ATTACHED!		090713		 09.07.13 P.V. 0451 042	6 09/07/13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45455

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0



D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Locknut

batch: 48238

Handwritten signature

21.0



D3798042

Spacepod Floor, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Floor, RH

batch: 45579

Handwritten signature

22.0



D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: B35455

Handwritten signature

23.0



D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

batch: 36226

Handwritten signature

24.0



D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ball Stud

batch: 37674

Handwritten signature

25.0



AN33A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M111925

Handwritten signature

26.0



AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M109752

Handwritten signature

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45455

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

✓ AN310A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M17566

28.0

✓ AN55A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch: M110363

29.0

✓ AN52510R7

Screw



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Screw

batch: M111477

30.0

✓ AN526C832R14

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104916

31.0

✓ MS24694S67

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Screw

batch: M104166

32.0

✓ MS24694S69

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

batch: M103574

33.0

✓ A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer - Countersunk

batch: M104106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45455

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1149D0363J

Washer

A-96-6010

QST 4.11



QST 4.11



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch:

M111668

35.0

NAS1149D0332J

Washer

A-96-6010L

QST 4.11



QST 014



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

batch:

M109632

36.0

NAS1149D0563J

Washer

A-96-60576

QST 4.11



QST 014



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

batch:

M111275

37.0

MS21042L3

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch:

M111274

38.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

batch:

M111227

39.0

AKS71032130

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

ALS7-1032-130

batch:

M111529

(AKS7-1032-130)

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

QST 4.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45455

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-780-042

Location:

PPP Rev:

DRAFT

169/17/14

42.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

✓



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	Part Number	Description
X						D130-780-041	SPACEPOD™ LH, EC 130 B4
	X					D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X				D130-780-043	DOOR ASSEMBLY, LH
	1		X			D130-780-044	DOOR ASSEMBLY, RH
1				X		D130-780-011	AFT LH DOOR HINGE KIT
1	1				X	D130-780-013	SWITCH RELOCATION KIT
2	2					D3815-041	WEB ASSEMBLY
						D2464-0360	NEOPRENE SEAL
		1	1			D2589	KEYS, KEY CHAIN
1	1					D3837-1	DECAL
1	1					D3015-3	LOCK NUT
		1				D3186-3	SPACEPOD™ DOOR, LH
			1			D3186-4	SPACEPOD™ DOOR, RH
1						D3798-041	FLOOR
	1					D3798-042	FLOOR
1						D3188-5	SPACEPOD™ BODY
	1					D3188-6	SPACEPOD™ BODY
1	1					D3547-1	BRACKET
1	1					D3550-1	STRUT
		1	1			D3552-7	GAS SPRING
1	1					D3554-7	BALL STUD
4	4					AN3-3A	BOLT
4	4					AN3-6A	BOLT
2	2					AN3-10A	BOLT
1	1					AN5-5A	BOLT
38	38					AN525-10R7	SCREW
8	8					AN526C832R14	SCREW
7	7					MS24694S67	SCREW
1	1					MS24694S69	SCREW
		2	2			MS27039-0811	SCREW
8	8					A3235-020-935	WASHER
8	8					NAS1149D0363J	WASHER
16	16					NAS1149D0332J	WASHER
		4	4			NAS1149DN832J	WASHER
3	3					NAS1149D0563J	WASHER
		2	2			NAS1515H3	NYLON WASHER
		2	2			MS21042L08	NUT
16	16					MS21042L3	NUT (or MS21042-3)
1	1					MS21042L5	NUT
10	10					AKS7-1032-130	INSERT
28**	28**					AKS7-1032-130	INSERT
					2	D3819-1	MALE SPADE CONNECTOR
					2	D3597-1	FEMALE SPADE CONNECTOR

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

-041	-042	-043	-044	-011	-013	Part Number	Description
					1	D3598-2-096	EXPANDABLE SLEEVE
					24	D3599-1	TIE-WRAP
					24	D3600-1	TIE-WRAP MOUNT
					24 FT	M22759/41-22-9	WIRE
		1*	1*			D2464-1250	NEOPRENE SEAL
1**		1*				D3837-3	DECAL
	1**		1*			D3837-4	DECAL
		2*	2*			D2586	LATCH
		2*	2*			D2585	MOUNTING CHANNEL
		2*	2*			D2621	LATCH PLATE
		2*	2*			MS27039-1-15	SCREW
		2*	2*			NAS1149D0363J	WASHER
		2*	2*			MS21042L3	NUT (or MS21042-3)
		1*	1*			D2857-1	HINGE BRACKET
		1*	1*			D2857-2	HINGE BRACKET
		2*	2*			D2228	BACKING PLATE
		8*	8*			AN526C832R10	SCREW
		8*	8*			NAS1149DN832J	WASHER
		8*	8*			MS21042L08	NUT
		1*	1*			D3557-1	BRACKET
		2*	2*			D2228	BACKING PLATE
		1*	1*			D3554-7	BALL STUD
		1*	1*			NAS1149D0563J	WASHER
		1*	1*			D3015-3	LOCK NUT
		2*	2*			AN526C832R14	SCREW
		2*	2*			AN526C832R10	SCREW
		4*	4*			NAS1149DN832J	WASHER
		4*	4*			MS21042L08	NUT
2**	2**					D2237	STRIKER PLATE
4**	4**					MS20426AD4-5	RIVET
2**	2**					D3538-1	HINGE BRACKET
2**	2**					D2179	HINGE BRACKET PLATE
4**	4**					AN526C832R24	SCREW
4**	4**					NAS1149DN832J	WASHER
4**	4**					MS21042L08	NUT
				1		D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***		D3518-3	ROD END
				2***		NAS509-6	NUT
				1		D3814-1	HINGE, UPPER AIRFRAME
				1		D3814-3	HINGE, LOWER AIRFRAME

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

-041	-042	-043	-044	-011	-013	Part Number	Description
				2		D3816-1	SPACER
				4		D3816-3	SPACER
				1		D3817-041	ANCHOR PLATE
				2		AN3-5A	BOLT
				3		AN3-7A	BOLT
				2		AN310-4	CASTLE NUT
				2		AN4-17	BOLT
				2		AN970-4	WASHER
				5		MS21042L3	NUT
				2		MS24665-212	COTTER PIN
				3		MS24694S46	SCREW
				8		NAS1149D0363J	WASHER
				2		NAS1149D0463J	WASHER
				1		D3552-7	GAS SPRING
				2		D3622-1	BALL STUD
				1		D3820-1	DOOR SUPPORT
				2		MS21042L5	NUT
				2		NAS1149D0563J	WASHER

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV: E SHEET 1 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

RELEASED

07.04.09 **[Signature]**

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:
 - RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 - FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES
 - FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

7) ALL DIMENSIONS ARE IN INCHES

8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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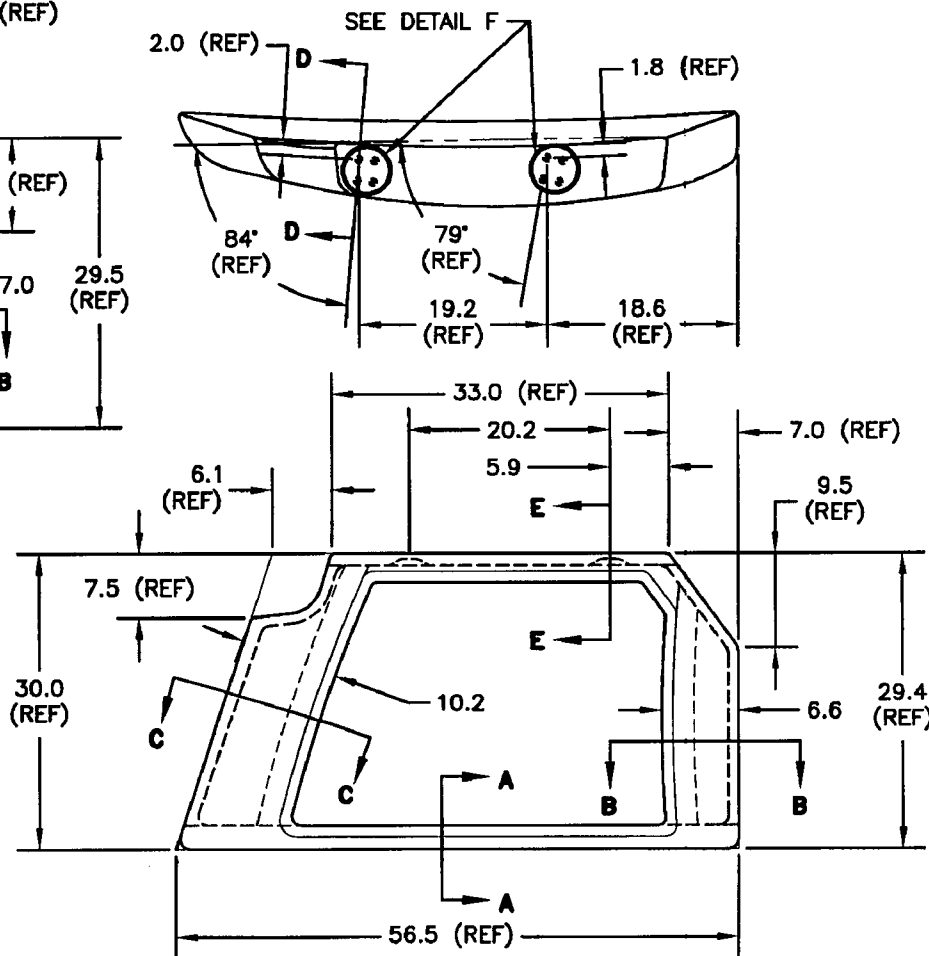
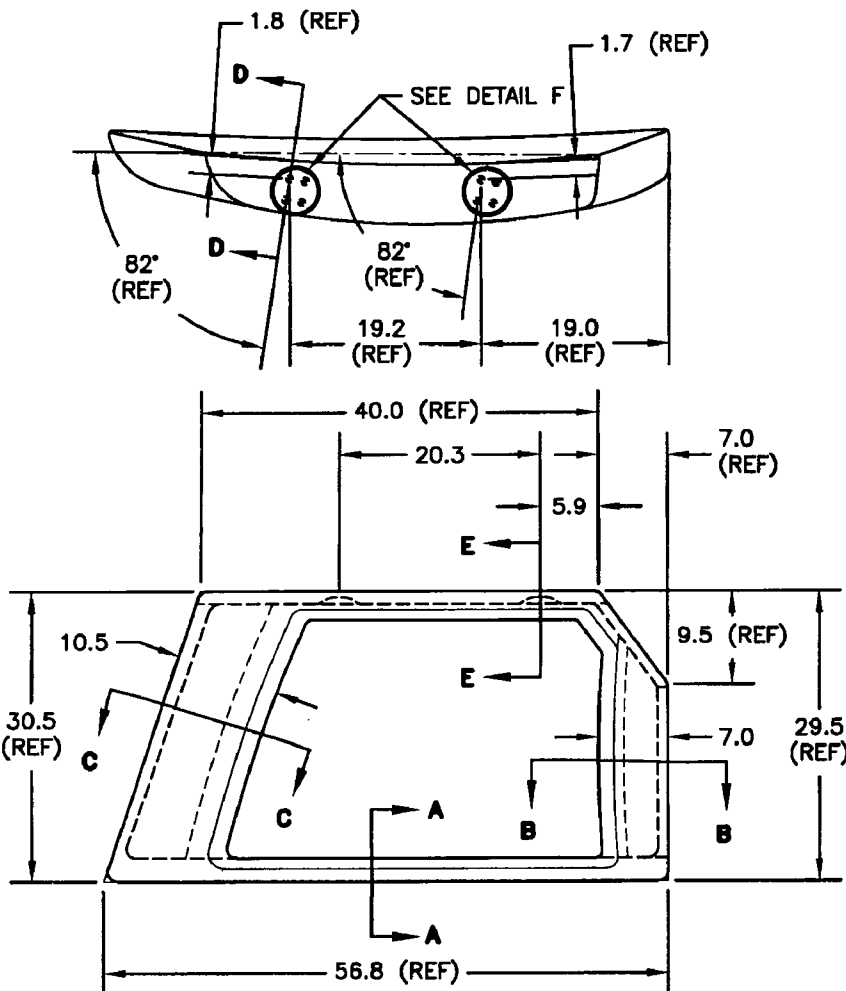
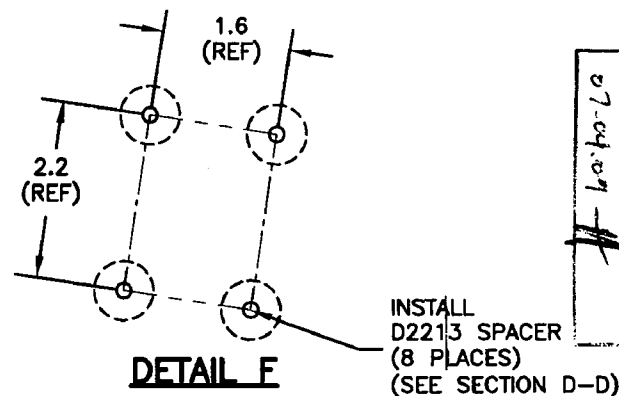
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			SPACEPOD BODY	SHEET 2 OF 11
				SCALE
				NTS



D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY

D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

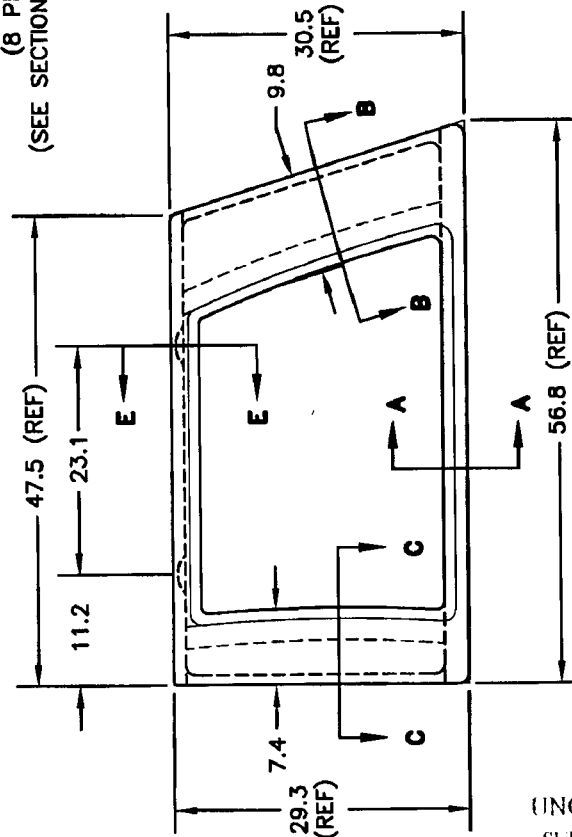
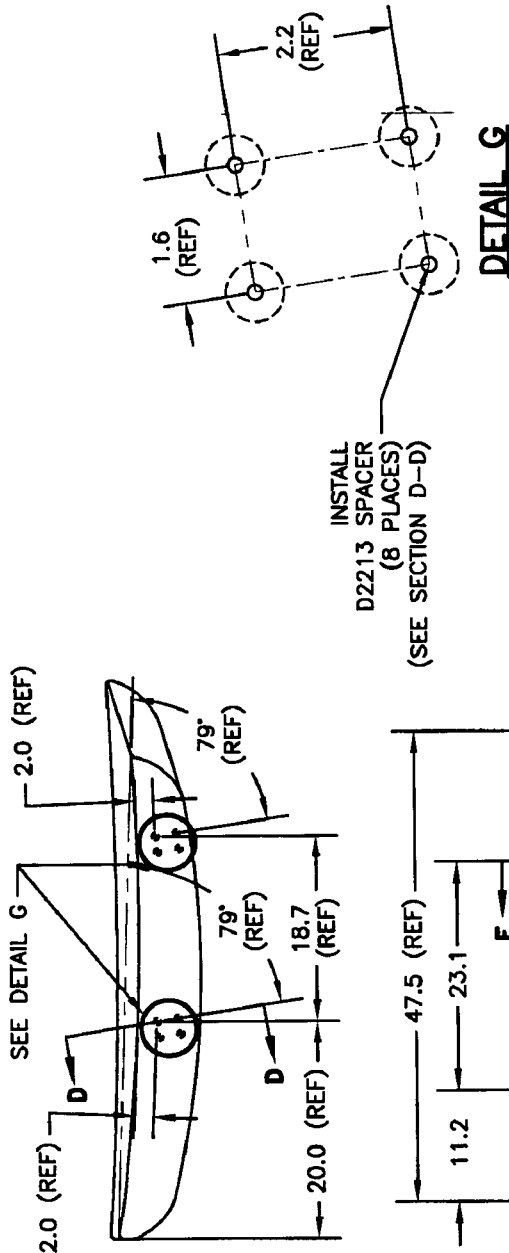
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D3188-2M SPACEPOD BODY

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D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

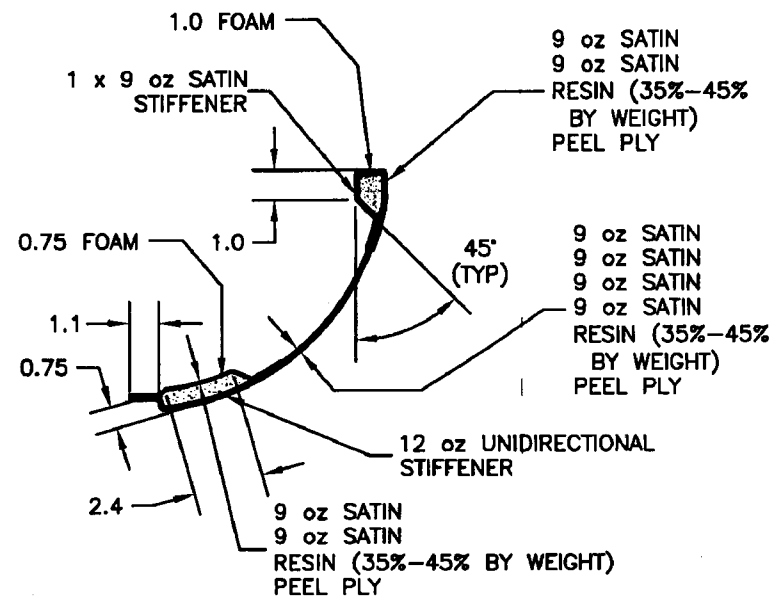
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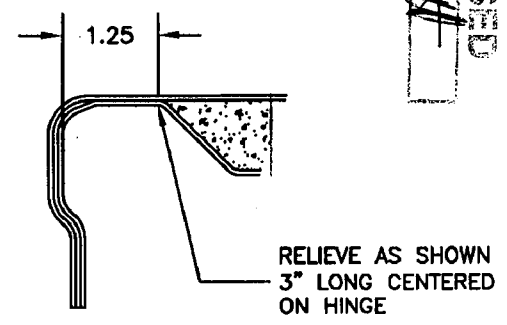


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		TITLE	SPACEPOD BODY	SHEET 4 OF 11	
				SCALE	
				NTS	

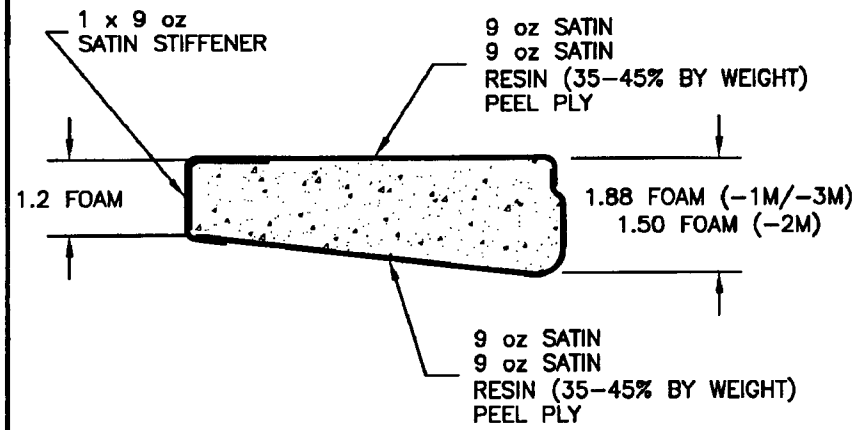
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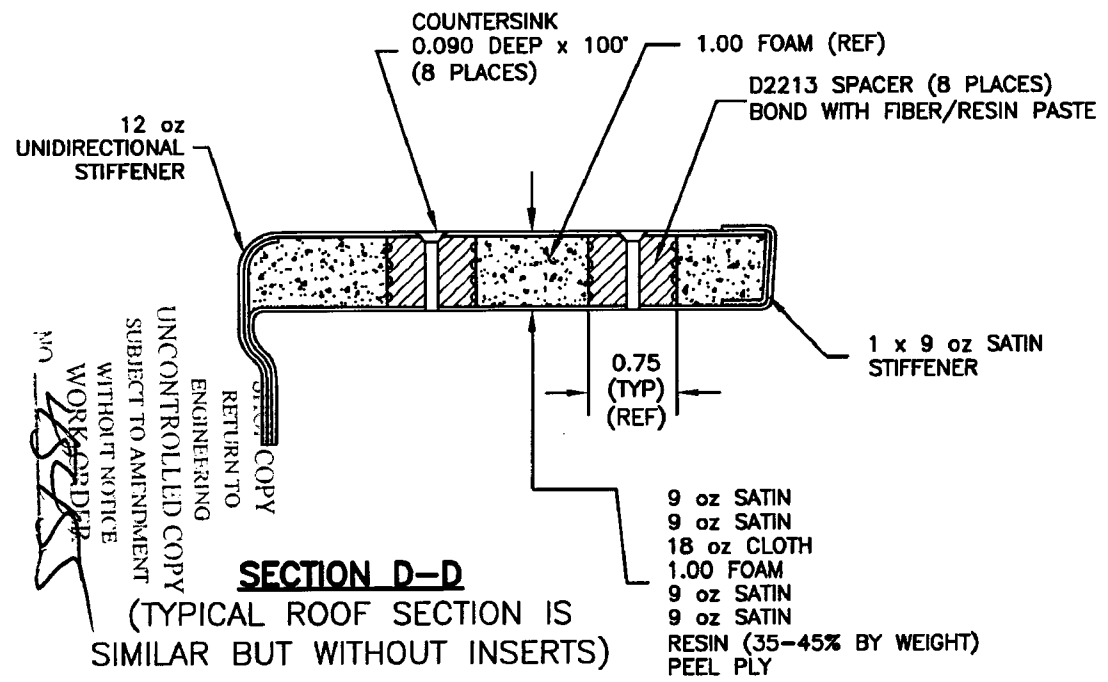
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION E-E
(2 PLACES PER POD)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)

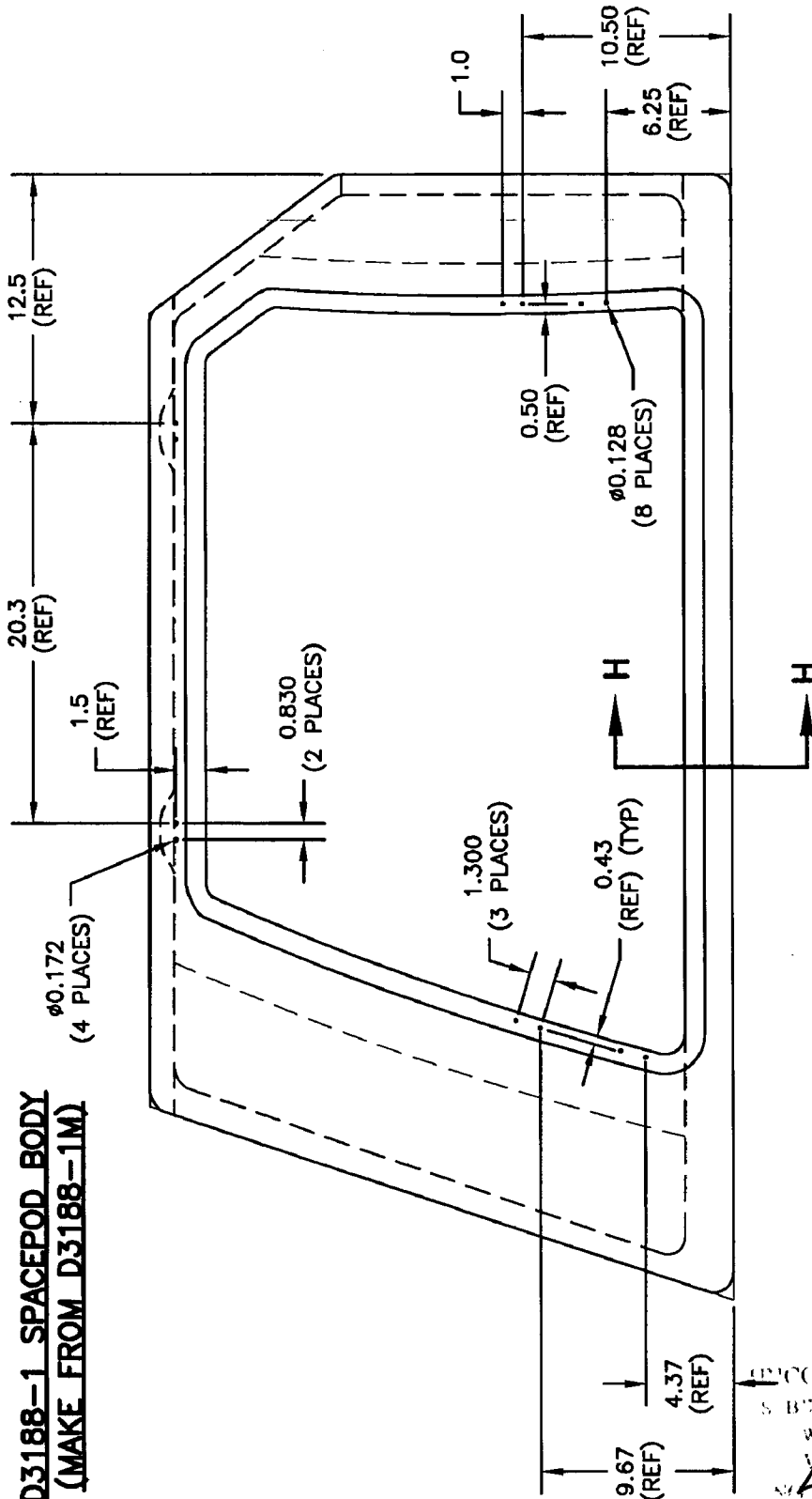
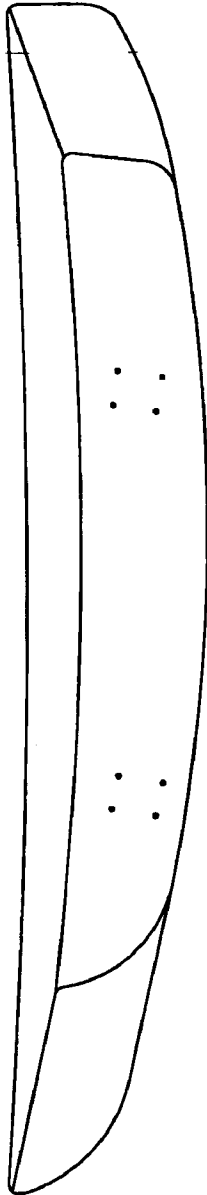
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D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

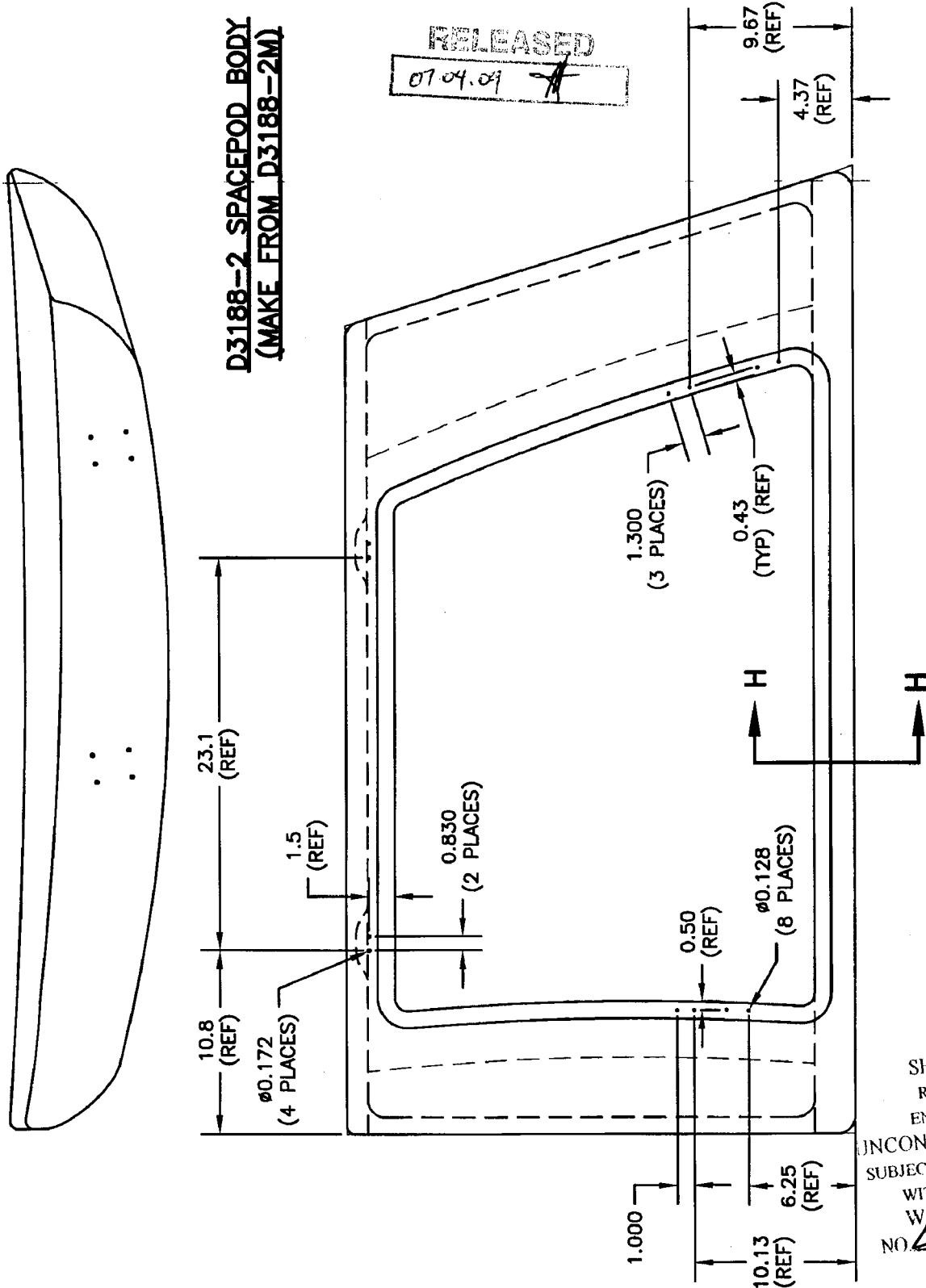
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2) SEE SHEET #11 FOR SECTION VIEW

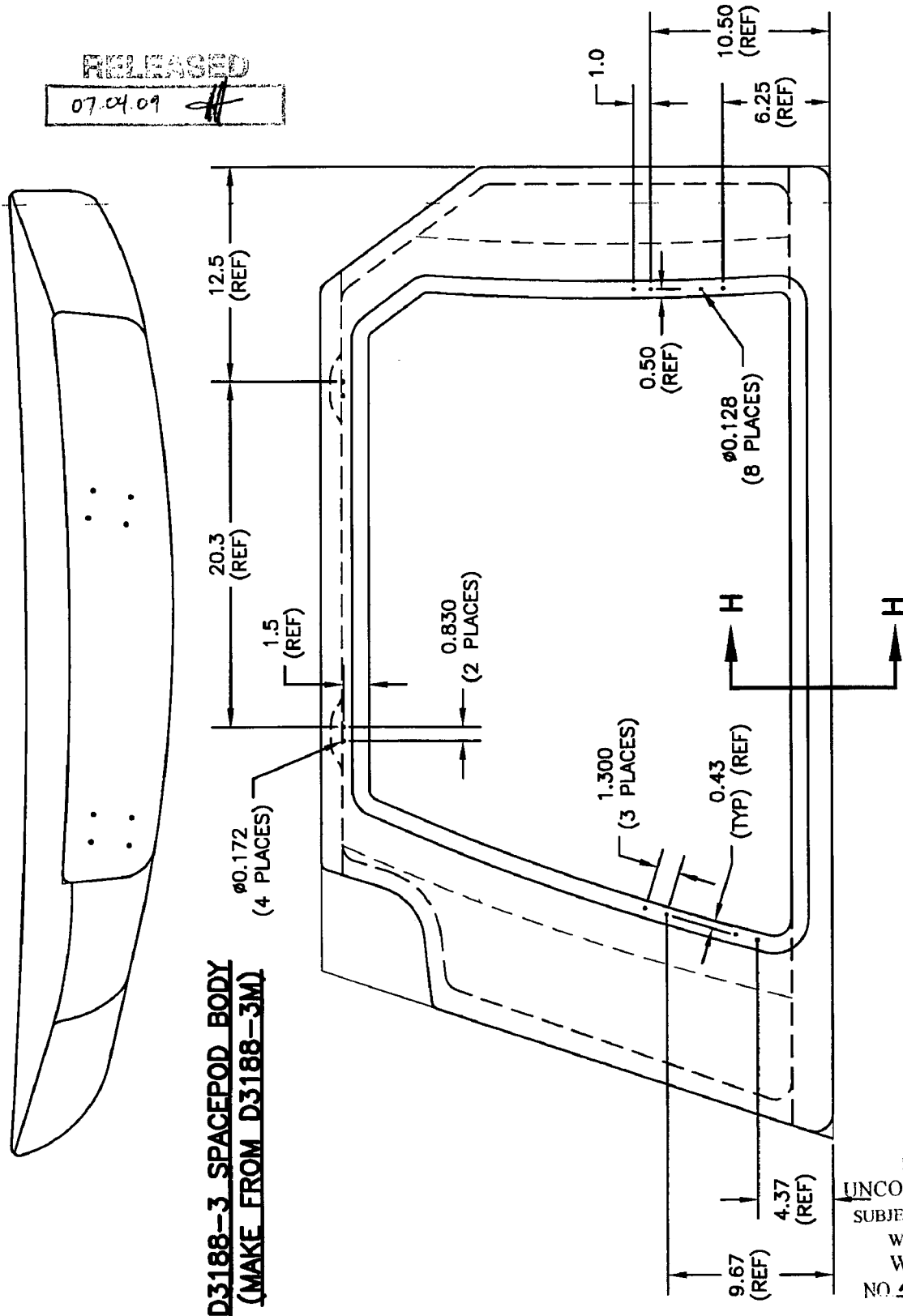
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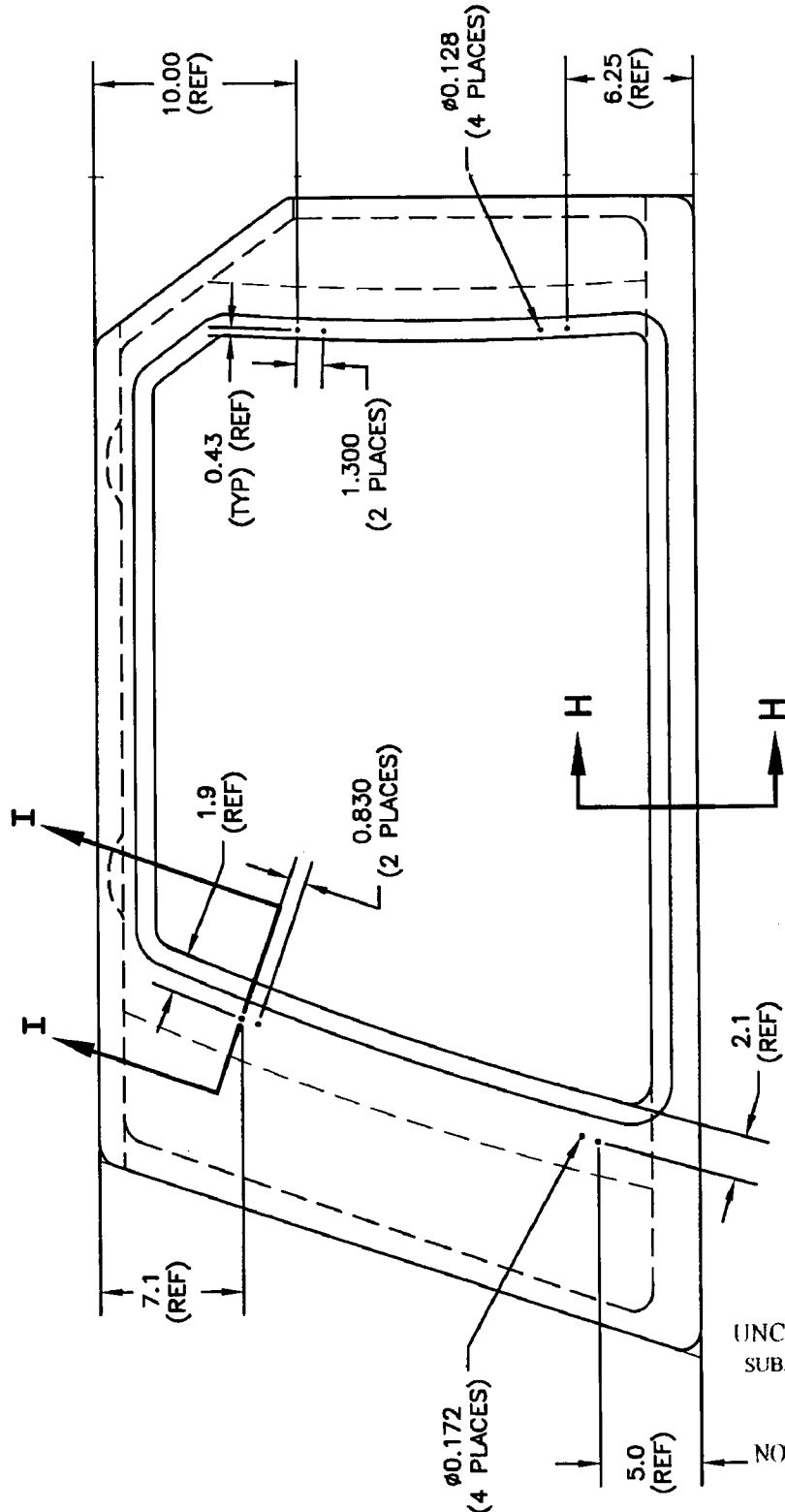
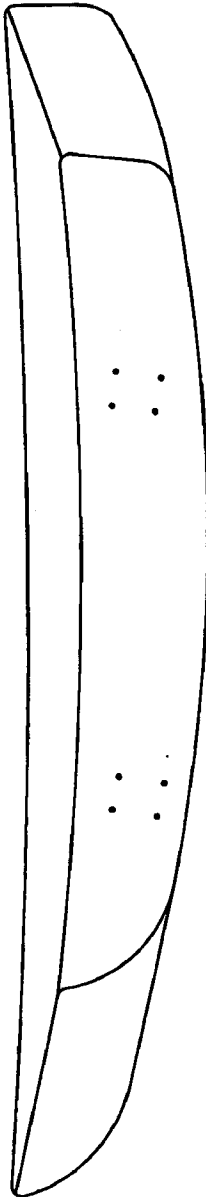


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D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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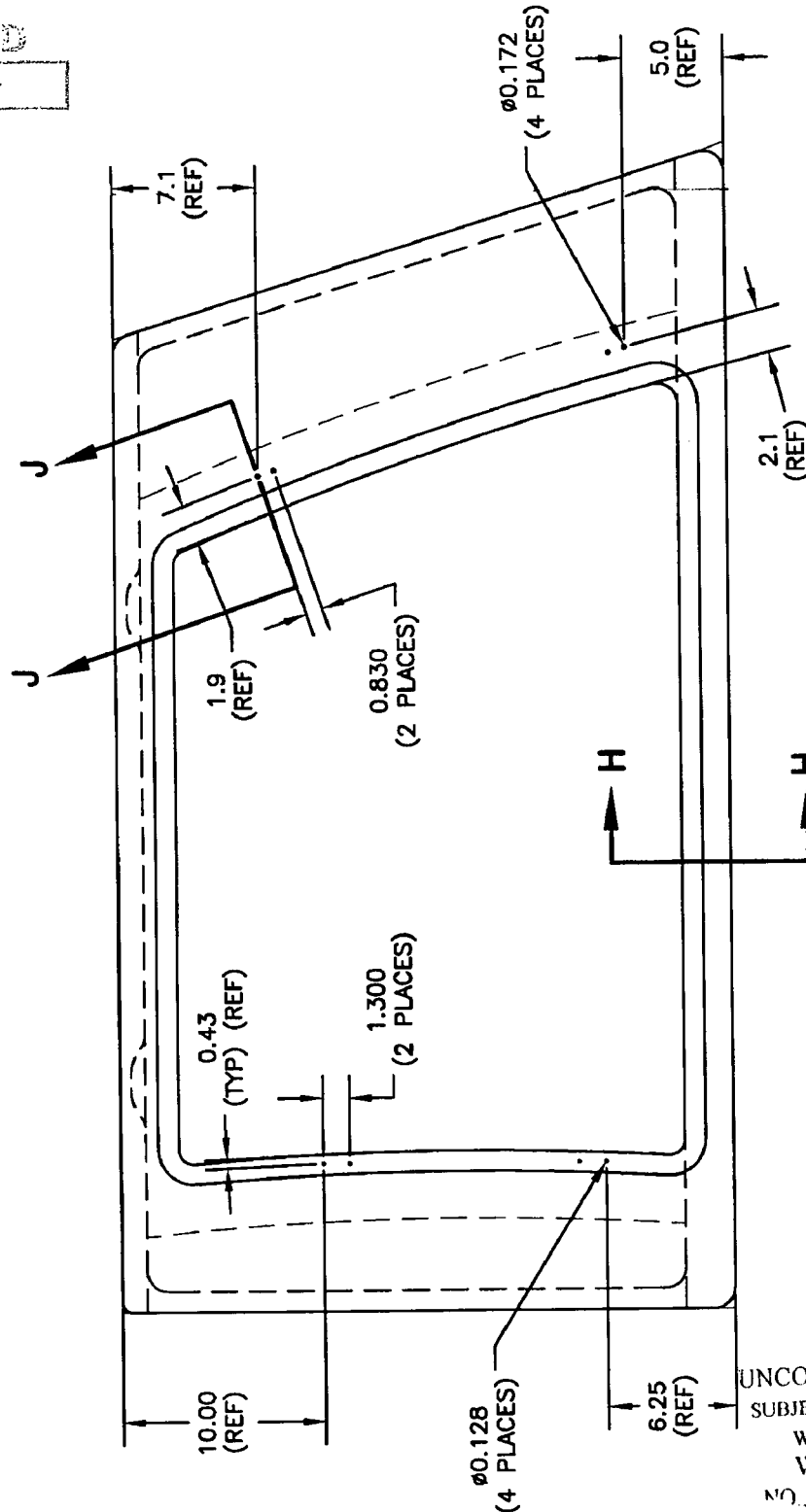
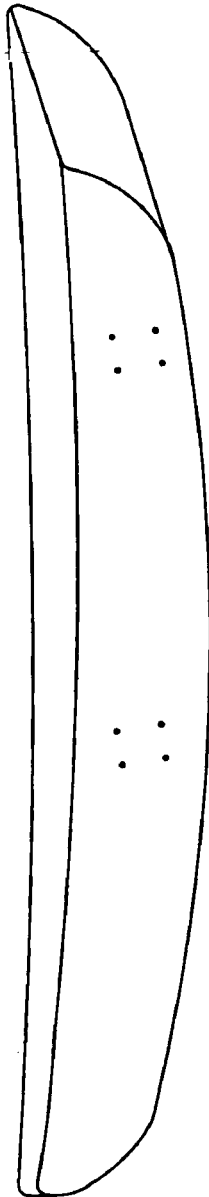
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NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
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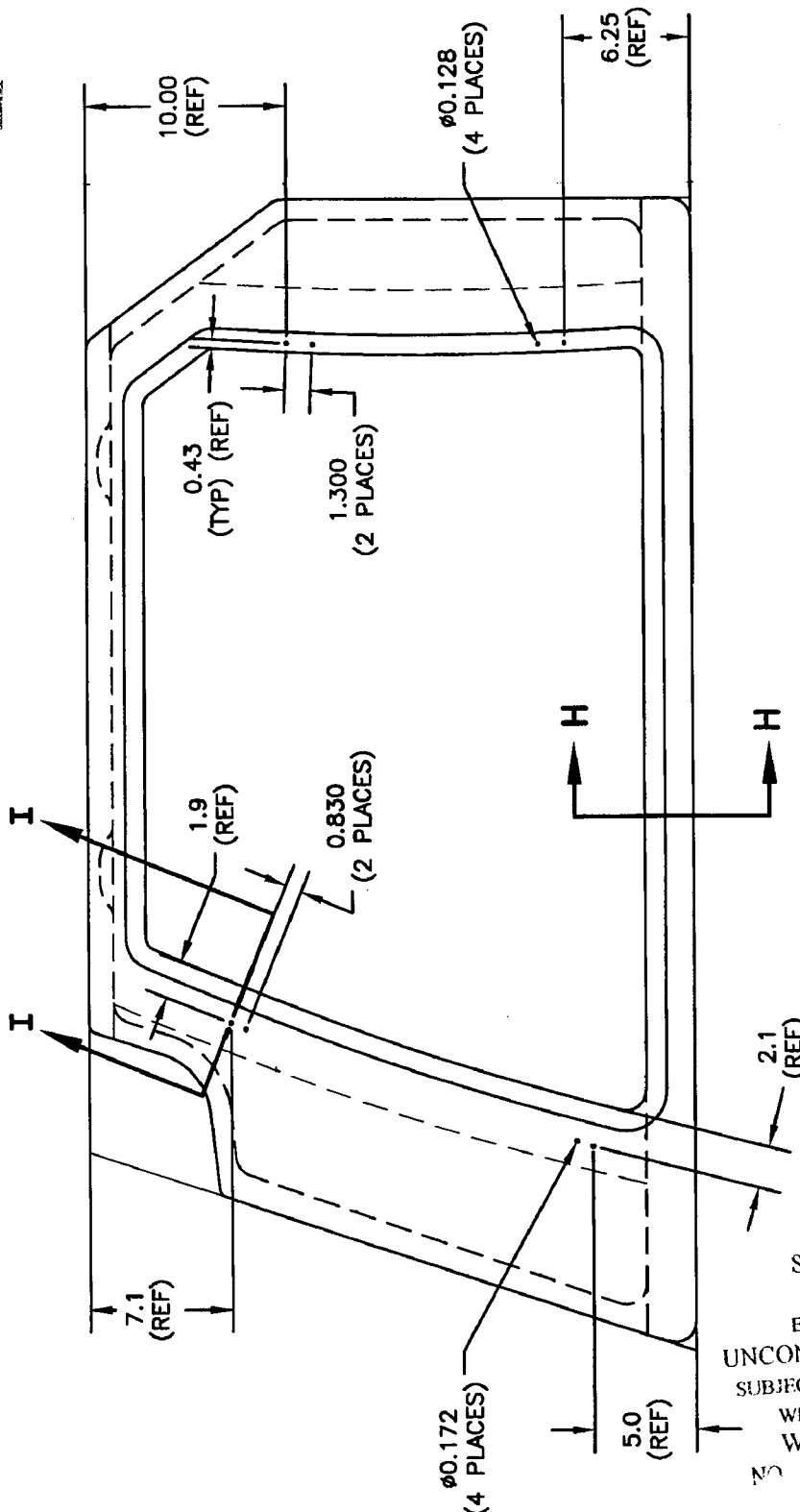
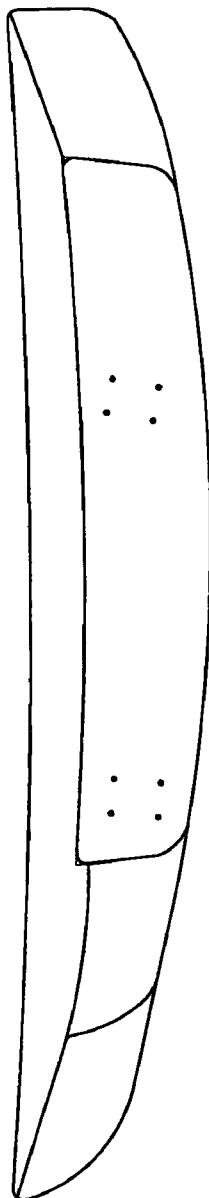
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**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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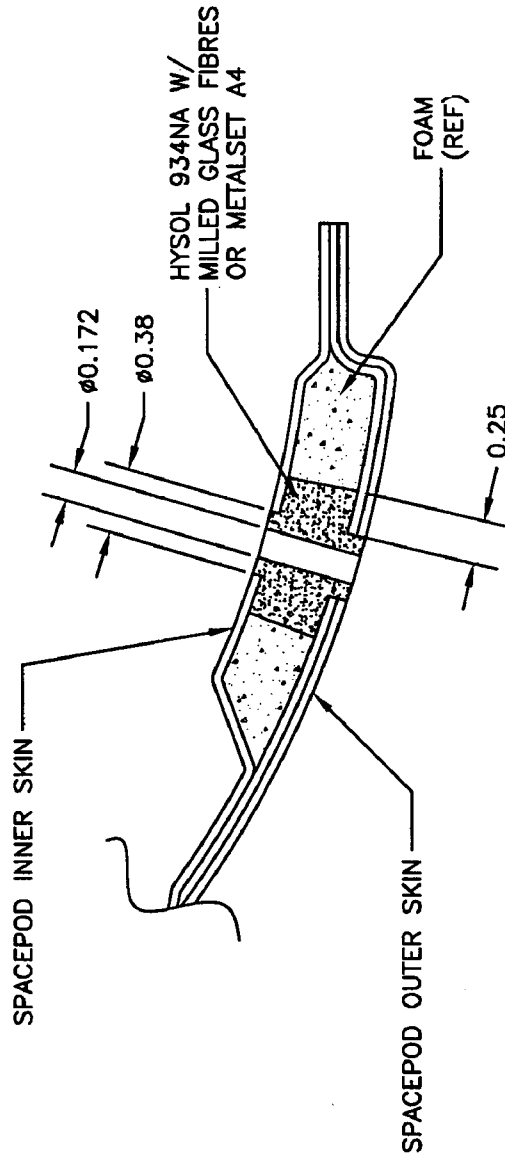
01.04.09

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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